

Work Order ID 81750

Friday, March 16, 2012 3:38:33 PM

81750

Page 1

Item ID: D350-607-541

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Utility-Basket

Start Date: 3/19/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/6/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: *WVF*Date: *12-03-11* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D350-607-3

A

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-607-541 CHG003

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label****

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Start Date: 3/19/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/6/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

Pick Kit

0.00

130

Packaging

Memo

0.00

Packaging

Package as per PPPD350-607-541

*SNIP**12/4/12*

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCJ 12/04/12
MF
12-04-04

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Work Order ID: 81750

Parent Item: D350-607-541

Parent Item Name: Heli-Utility-Basket

Start Date: 3/19/2012

Required Date: 4/6/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10-08-19 AS PER REV.A DD VERF BY:EC IPP Rev:B 11.02.09 add to install label DD verf by:EC IPP REV:C 12.03.06 AS PER ECN12-535 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D350-607-511
Quick Release Basket Mounting Installation

Manufactured No

110 Each 5.0000

1 1 81429 C

Location Loc Qty Loc Code

FG 2

80948 2

FG032 3

81191 3

D2690-6
Lanyard Assembly

Manufactured No

110 Each 21.0000

1 1 JB

Location Loc Qty Loc Code

ST016 21

79515 21

D3912-041
Eyebolt Receiver Assembly

Manufactured No

110 Each 0.0000

1 1 79515 JB

D4030-041
Long Basket Assembly (350)

Manufactured No

110 Each 0.0000

1 1 81406 JB

D4085-3
Placard, Instructions

Manufactured No

110 Each 5.0000

1 1 81753 JB

Location Loc Qty Loc Code

ST122 5

78972 5

D4151-041
Basket Fwd Hardpoint Assembly, Lower

Manufactured No

110 Each 6.0000

1 1 78972 JB

Location Loc Qty Loc Code

ST131 2

78970 2

ST134 4

79354 4

1 1 79354

12/03/30

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Parent Item: D350-607-541

Parent Item Name: Heli-Utility-Basket

Start Date: 3/19/2012

Required Date: 4/6/2012

Start Qty: 1.00

Required Qty: 1.00

D4151-043

Basket Fwd Hardpoint Assembly, Upper

Manufactured No

110 Each 3.0000

1 1 81469

LocationLoc QtyLoc Code

ST134

3

80727

3

D4150-041

Attachment Arm Assembly

Manufactured No

110 Each 1.0000

1 1 408 81379

LocationLoc QtyLoc Code

ST134

1

80726

1

AN4-13A

Bolt

Purchased No

110 Each 1,357.0000

6 6 ✓ JB

LocationLoc QtyLoc Code

ST357

1357

119449

59

120187

398

120422

500

120770

400

120187

AN4C15

BOLT

Purchased No

110 Each 35.0000

1 1 ✓ JB

LocationLoc QtyLoc Code

ST358

35

120124

35

120124

AN310C4

Nut

Purchased No

110 Each 46.0000

1 1 ✓ JB

LocationLoc QtyLoc Code

ST344

46

119324

16

120360

30

119324

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Parent Item: D350-607-541

Parent Item Name: Heli-Utility-Basket

Start Date: 3/19/2012

Required Date: 4/6/2012

Start Qty: 1.00

Required Qty: 1.00

MS17984-C413

PIN, QUICK RELEASE

Purchased

No

110

Each

12.0000

[1]

1

LocationLoc QtyLoc Code

ST315

3

114340

1

118612

2

ST333

9

121011

9

121011

MS21042L4

Nut

Purchased

No

110

Each

5,519.0000

[6]

6

LocationLoc QtyLoc Code

ST300

5519

117441

51

117601

157

118451

133

119017

200

119075

2978

121011

2000

119075

MS24665-151

Cotter Pin

Purchased

No

110

Each

311.0000

[1]

1

LocationLoc QtyLoc Code

ST309

311

17566

311

17566

NAS1515H4L

WASHER

Purchased

No

110

Each

447.0000

[2]

2

LocationLoc QtyLoc Code

FG

8

103691

8

ST277

439

118709

4

120390

435

120390

12/03/30

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Parent Item: D350-607-541

Parent Item Name: Heli-Utility-Basket

Start Date: 3/19/2012

Required Date: 4/6/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0432P

Washer

Purchased

No

110

Each

322.0000

12

12

Location

Loc Qty

Loc Code

ST275

322

120360

122

121060

200

121060

NAS1149C0463R

Washer

Purchased

No

110

Each

1,014.0000

3

3

Location

Loc Qty

Loc Code

FP001

1

115358

1

ST297

1013

117735

34

119097

979

119097

12/03/30

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-607-541 (Standard Basket)	80.7 lb 36.6 kg	± 49.1 in ± 1.25 m	± 3962 in-lb ± 45.8 m-kG	135 in 3.43 m	10895 in-lb 125.5 m-kG
D350-607-543 (Lightweight Basket)	65.7 lb 29.8 kg	± 49.1 in ± 1.25 m	± 3226 in-lb ± 37.3 m-kG	135 in 3.43 m	8870 in-lb 102.2 m-kG
D350-607-545 (Standard Basket)	58.7 lb 26.2 kg	± 49.1 in ± 1.25m	± 2882 in-lb ± 32.8 m-kG	135 in 3.43 m	7925 in-lb 89.9 m-kG
D350-607-547 (Lightweight Basket)	47.7 lb 21.6 kg	± 49.1 in ± 1.25 m	± 2342 in-lb ± 27.0 m-kG	135 in 3.43 m	6440 in-lb 74.1 m-kG
D350-607-511 (Quick Release Basket Mounting Kit)	7.2 lb 3.3 kg	± 36.9 in ± 0.94 m	± 266 in-lb ± 3.1 m-kG	135 in 3.43 m	972 in-lb 11.3 m-kG

5.0 PARTS LIST

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET
	X					D350-607-543	HELI-UTILITY-BASKET
		X				D350-607-545	HELI-UTILITY-BASKET
			X			D350-607-547	HELI-UTILITY-BASKET
/ 1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT
					X	D350-607-501	CONVERSION KIT
/ 1	1	1	1		1	D2690-6	LANYARD
				4	4	D3910-3	X-TUBE LUG
/ 1	1	1	1		1	D3912-041	EYEBOLT RECEIVER ASSY
				8	8	D3984-030	RUBBER EXTRUSION, X-TUBE
/ 1						D4030-041	LONG BASKET ASSY
	1					D4030-043	LONG BASKET ASSY, LIGHTWEIGHT
		1				D4032-041	SHORT BASKET ASSY
			1			D4032-043	SHORT BASKET ASSY, LIGHTWEIGHT
/ 1	1	1	1		1	D4085-3	PLACARD-INSTRUCTIONS
1					1	D4086-200	PLACARD, MAX LOAD
	1				1	D4086-215	PLACARD, MAX LOAD
		1			1	D4086-220	PLACARD, MAX LOAD
			1		1	D4086-232	PLACARD, MAX LOAD
				1	1	D4148-041	FWD X-TUBE LUG ASSY
				1	1	D4149-041	AFT X-TUBE LUG ASSY
/ 1	1	1	1		1	D4150-041	ATTACHMENT ARM ASSY
/ 1	1	1	1		1	D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
/ 1	1	1	1		1	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
6	6	6	6		6	AN4-13A	BOLT
				16	16	AN4-14A	BOLT
/ 1	1	1	1		1	AN4C15	BOLT
/ 1	1	1	1		1	AN310C4	CASTELLATED NUT
/ 1	1	1	1		1	MS17984-C413	QUICK RELEASE PIN
6	6	6	6	16	22	MS21042L4	NUT (OR MS21042-4)
1	1	1	1		1	MS24665-151	COTTER PIN
2	2	2	2		2	NAS1515H4L	WASHER
12	12	12	12	32	44	NAS1149F0432P	WASHER
3	3	3	3		3	NAS1149C0463R	WASHER

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Revision: A

Date: 10.06.28